

JDS

Date: Thursday, 02/04/2009 2:27:45 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)  
 Job Number : 46872  
 Estimate Number : 13260  
 P.O. Number :  
 This Issue : 02/04/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D350766011  
 First Issue : / / Type : THERMOFORMING Drawing Number : IIN350-766 REV A  
 Previous Run : 46871 Drawing Revision : A  
 Material :  
 Due Date : 17/04/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09-04-03  
 Comment : Est REV A NEW ISSUE 08/04/08 DL verified by:DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for JUD 09/04/15



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 CHG001

002 S 09/04/15

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D36551 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 39492

1 09/04/15

4.0 D36553 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: B47020

09/04/15

5.0 MS21059L3 Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

batch: M107394

09/04/15 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)

Job Number: 46872

Part Number: D350766011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CCR274SS34

Cherry Rivet



Comment: Qty.: 8.0000 (s)/Unit Total: 8.0000 (s)

Cherry Rivet

batch:

M107438

SS 09/04/15 (X)

7.0

AN5261032R12

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M1568

SS 09/04/15 (X)

8.0

AN5261032R20

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M10216

SS 09/04/15 (X)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/04/15 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-766-011

Location:

PPP Rev:

B

SS 09/04/16 (1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/04/17 (A)

Job Completion



ME 09-04-16

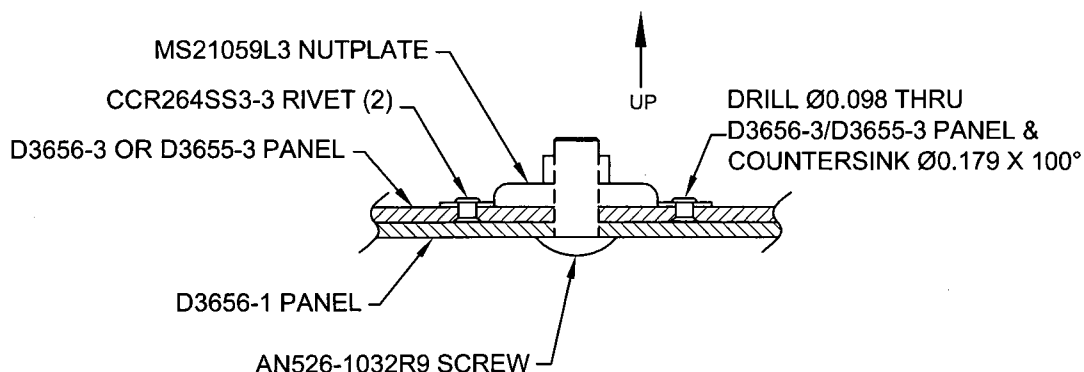
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Figure 6 – Nutplate Installation**

#### 4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
<b>D350-766-011</b> Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
<b>D350-766-013</b> Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg

#### 5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		<b>D350-766-011</b>	<b>INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)</b>
	X	<b>D350-766-013</b>	<b>INTERIOR TRIM KIT (CEILING TRIM KIT)</b>
1		D3655-1	PANEL
1		D3655-3	PANEL
	1	D3656-1	PANEL
	1	D3656-3	PANEL
4	15	MS21059L3	NUTPLATE
	30	CCR264SS3-3	RIVET
8		CCR274SS3-4	RIVET
	15	AN526-1032R9	SCREW
2		AN526-1032R12	SCREW
2		AN526-1032R20	SCREW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 46872